

SEE M. BELLAVANCE

CUSTOM Part.

Work Order ID 134024

134024

Wednesday, June 24, 2015 9:54:50 AM

Page 1

Item ID: D4704-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Expandable Pin Assembly

Start Date: 6/24/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/15

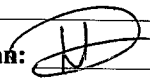
Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 15.6.24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4704

A

110

Pick Kit

0.00

DAS

30

9-89

JUN 24 2015

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG USE DT9882, DT9883

IX

15/06/24

DAS

36

9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

D

DAS

38

9-89

JUN 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____							

Work Order ID 134024

134024

Wednesday, June 24, 2015 9:54:50 AM

Page 2

Item ID: D4704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Expandable Pin Assembly
 Start Date: 6/24/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/25/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>52d</u>	0.00							DAS 02 9-89
140									
Packaging	Memo	0.00							
Packaging									JUN 24 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							MLJ JUN 24 2015
Quality Control									

Handwritten signature/initials and date: 6-24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Wednesday, June 24, 2015 9:54:54 AM

Page 1

Work Order ID: 134024

134024

Parent Item: D4704-041

D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 6/24/15

Required Date: 6/25/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS
12.10.16 AS PER DWG REV.A DD VERF:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-1 *D4708-1* Lanyard		Manufactured	No			110	Each	34.0000	1	1		DAS 30 9-89	JUN 24 2015
				<u>Location</u>				<u>Loc Qty</u>					
				ST123				34					
				126258				33					
				133758				1					
D4709-1 *D4709-1* Spring Clip		Manufactured	No			110	Each	6.0000	2	2		DAS 30 9-89	JUN 24 2015
				<u>Location</u>				<u>Loc Qty</u>					
				ST123				6					
				129779				6					
D4711-041 *D4711-041* Expandable Pin Assembly, Modified		Manufactured	No			110	Each	2.0000	2	2		DAS 30 9-89	JUN 24 2015
				<u>Location</u>				<u>Loc Qty</u>					
				ST123				2					
				128934				2					
MS20613-4C8 *MS20613-4C8* Rivet		Purchased	No			110	Each	232.0000	4	4		DAS 30 9-89	JUN 24 2015
				<u>Location</u>				<u>Loc Qty</u>					
				ST307				232					
				120242				232					

MS20613-4C7

M129036

2X

15/06/24 ef.

DQA: _____ Date: _____



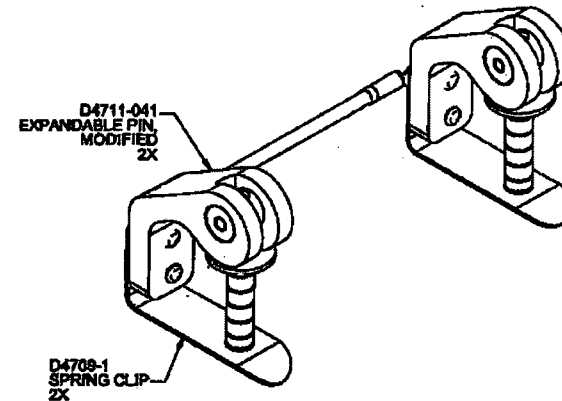
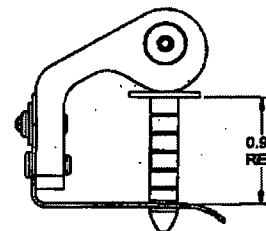
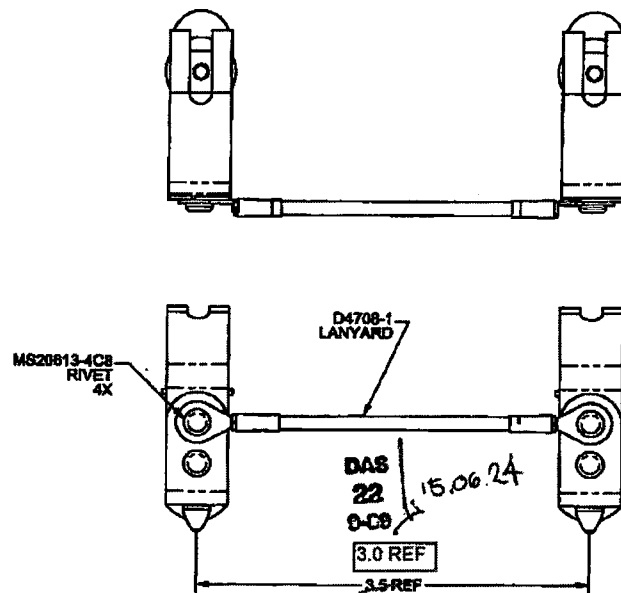
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOIM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY	PIN	DESCRIPTION
	X	D4704-041	EXPANDABLE PIN ASSY
1	2	D4711-041	EXPANDABLE PIN, MODIFIED
2	1	D4708-1	LANYARD
3	2	D4709-1	SPRING CLIP
4	4	MS20813-4C8	RIVET



D4704-041 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D4704-041" AND S/N "BX00000" PER QSI 044 & 1
- 7) WEIGHT: 0.39 lbs

A		NEW ISSUE		RP	12.08.19
REV.	DESCRIPTION	BY	DATE		
DESIGN	RP	DART AEROSPACE USA, INC.			
DRAWN	RP	KENT, WA			
CHECKED	RP	DRAWING NO.	REV. A		
MFG. APPR.	RP	D4704	SHEET 1 OF 1		
APPROVED	RP	TITLE	SCALE		
DE APPR.	RP	EXPANDABLE PIN ASSY	NTS		
DATE	12.08.19	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC.			

Handwritten: DB-624
1340241

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